

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019537**Date Inspected:** 27-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

ZPMC personnel doing the fit-up of Deck Panel (DP) 3120A, DP3121A and DP3122A with the Segment / assembly. See attached photo for further information.

Repair welding of weld joint nos: SEG3013AH-044 [K-Plate KP3016A to Side Panel (SP) 3101A, complete joint penetration (CJP) weld at PP118.35 – PP120]. The welder is identified as 067707 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS:

345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): CWR B-WR 02777 Rev-0.

Repair welding of weld joint nos: SEG3013AA-014 [Floor Beam (FB) 3178A to I-rib stiffener on SP3090C, CJP weld at PP118]. The welder is identified as 066261 and was observed welding in the 4G position. Welding process

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was identified as SMAW. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per welding repair report (WRR): B-WR 20128 Rev-0.

OBG Seg 14W:

Repair welding of weld joint nos: SEG3020K-023 [Longitudinal Diaphragm (LD) 3050A to sub-assembly SA3410, CJP weld at PP127.3]. The welder is identified as 045246 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per CWR: CWR B-WR 02690 Rev-0.

This QA Inspector observed ZPMC personnel performing back – gouging on weld no: SEG3020AG-004 at PP125. Pre-heating was observed to be done before performing back gouging. See attached photo for further information.

This QA Inspector observed ZPMC personnel performing assembly / fit-up of Anchorage Plate with the Vertical Sub-Assembly plates. See attached photo for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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| Inspected By: | Wadkar,Sailesh |
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| Quality Assurance Inspector |
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| Reviewed By: | Peterson,Art |
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| QA Reviewer |
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